

Work Order ID 64802-2

Friday, December 17, 2010 7:57:53 AM



Page 1

Item ID: D2348

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 12/16/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 12/17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2348

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2348

Dwg Rev: 2

Prog Rev: 2

2-Deburr if necessary

B1d-1-3

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Subsides

H6

Work Order ID 64802



Page 2

Friday, December 17, 2010 7:57:53 AM

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Accept



Setup Start



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Item Name: Wearplate

Start Date: 12/16/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

0.00

0.00

11.01.04

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

11.01.04

150



Outsource4

Outsource process - Anodize

Outsource process-Anodize per QSI017 4.1.10.1

Memo

Issue P/O:

13226

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

0.00

0.00

CL 11/01/06 (16)

Work Order ID 64802

Friday, December 17, 2010 7:57:53 AM



Page 3

Item ID: D2348

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/16/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

11/16/17 (14)

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

INSPECT CERTS

Subtotal 7

(16)

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Insert as per Dwg D2348

EP 11/02/23 (4)

Work Order ID 64802

Friday, December 17, 2010 7:57:53 AM

Page 4

Item ID: D2348

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 12/16/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

8/10/2/103



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 11

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04

mf
16-02-07

Picklist Print

Friday, December 17, 2010 7:57:57 AM

Page 1

Work Order ID: 64802

Parent Item: D2348

Parent Item Name: Wearplate



Start Date: 12/16/2010

Start Qty: 12.00

Required Date: 1/19/2011

Required Qty: 12.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

148.6340

0.0198

0.250105



116308

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT

111

116308

111

116308

MAT21

37.634

113608

37.634

D3996-FE-832-EF

Manufactured

No

180

Each

61.0000

4

48



8/5/02/03

Self-Clinching Fastener

Location

Loc Qty

Loc Code

ST107

61

54162

61

18

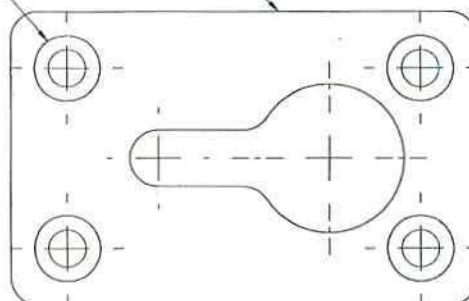
FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	10.06.04	Dimensions update per Dwg Rev C	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLA. PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

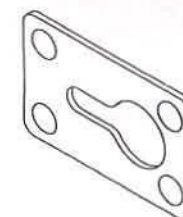
D2348F



D2348 WEAR PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64802

09-10-17

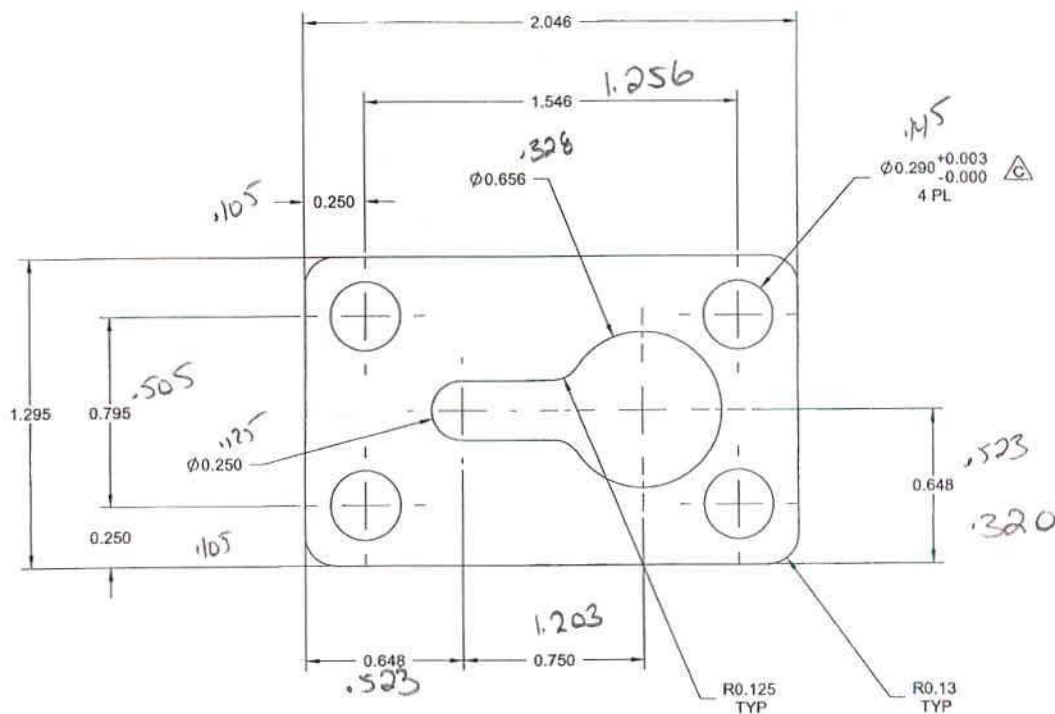


RELEASED
2009-11-09
[Signature]

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T8	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2348	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>	



D2348F FLAT PATTERN

RELEASED
2009-11-08
MD

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/C/III CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LS	DRAWING NO.	REV. C
MFG. APPR.	MD	D2348	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEAR PLATE	NTS
DATE	09.10.01	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13226

Purchase Order Date 1/06/11

PO Print Date 1/06/11

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

514 429 7777

514 429 5108

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
C/L 1/06/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	64802	D2348 WEARPLATE	1/14/11 Yes	16.00	Purolator ground	\$6.2500	\$100.00

Special Inst: ANODIZE BLACK AS PER DWG D2348
REV. C
B64802
FINISH BLACK ANODIZE AS PER MIL-A-
8625-F TYPE 1/1B/1C/11B
CLASS 2

PO Total:

\$100.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 1/06/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



21 chemin de l'Aviation, Pointe-Claire
QC H9R 4Z2
Canada
Phone:514-429-7777 Fax:514-429-5108
EMail:info@tnminc.ca

Packing Slip

DATE PACKING SLIP #

1/14/2011

- 88824



BILL TO:

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
13226	0094	NET 30		1/14/2011	Purolator		130314-001

PO Line#: 1

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
16	16	0	P/N:D2348 TNM-REV:P1 Minimum Charge

Sign Here: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

Packing Slip PACK01 REV: PACK01



Anodisation & Peinture TNM Inc

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 88824



1/14/2011

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

PURCHASE ORDER /
NO. DE COMMANDE: 13226

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	16	16	P/N:D2348 TNM-REV:P1 B64802 FITTING-WEARPLATE MAT'L: ALUMINUM	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8/16/12

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.
NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

